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(54) Title: **LOW PERMEABILITY NANOCOMPOSITES**

(57) Abstract: The present invention is a blend of an halogenated elastomer and a clay, desirably an exfoliated clay, to form a nanocomposite suitable for an air barrier. In one embodiment, the halogenated elastomer is a polymer comprising C₄ to C₇ isoolefin derived units, a para-methylstyrene derived units, and para-(halomethylstyrene) derived units. In another embodiment, the halogenated elastomer is a butyl-type rubber. The clay may or may not have an additional exfoliating treatment present prior to blending with the interpolymer. The interpolymer/clay mixture forms a distinct phase in the nanocomposite blend of the invention. The blend of the invention has improved air barrier properties and is suitable as an innerliner or innertube.

TITLE: LOW PERMEABILITY NANOCOMPOSITES**FIELD OF THE INVENTION**

The present invention provides a low-permeability nanocomposite useful for air barriers which is a blend of an elastomer, vulcanized or unvulcanized, a nano-filler such as a clay, and an exfoliating additive including long-chain tertiary amines and functionalized amines.

BACKGROUND

Nanocomposites are polymer systems containing inorganic particles with at least one dimension in the nanometer range. Some examples of these are disclosed in US 6,060,549, 6,103,817, 6,034,164, 5,973,053, 5,936,023, 5,883,173, 5,807,629, 5,665,183, 5,576,373, and 5,576,372. A common type of inorganic particle used in nanocomposites are phyllosilicates, an inorganic substance from the general class of so called "nano-clays" or "clays". Ideally, intercalation should take place in the nanocomposite, wherein the polymer inserts into the space or gallery between the clay surfaces. Ultimately, it is desirable to have exfoliation, wherein the polymer is fully dispersed with the individual nanometer-size clay platelets. Due to the general enhancement in air barrier qualities of various polymer blends when clays are present, there is a desire to have a nanocomposite with low air permeability; especially a dynamically vulcanized elastomer nanocomposite such as used in the manufacture of tires.

The preparation of elastomer-clay nanocomposites uses a number of methods to generate exfoliated clays. One of the most common methods relies upon the use of organically modified montmorillonite clays. Organoclays are produced through solution based ion-exchange reactions that replace sodium ions that exist on the surface of sodium montmorillonite with alkyl or aryl ammonium ion compounds. One of the deficiencies of this method is the limited thermal stability of the amines. A second is the lack of chemical bonding with the matrix,

often leading to poor mechanical properties and increased hysteresis. A third is the negative impact that the release amines and degradation products have on the transport properties.

5 One method to improve the organoclay performance is to use functionalized polymers to treat the clay. This approach has been limited to materials that are soluble in water or to materials that can be incorporated into the polymerization reaction. This approach has been used to prepare nylon nanocomposites, using for example, oligomeric and monomeric caprolactam as
10 the modifier. Polyolefin nanocomposites, such as polypropylene nanocomposites, have utilized maleic anhydride grafted polypropylenes to achieve some success in the formation of nanocomposites.

 For example, it is known to utilize exfoliated-clay filled nylon as a high
15 impact plastic matrix, such as disclosed in US 6,060,549 to *Li et al.* In particular, *Li et al.* disclose a blend of a thermoplastic resin such as nylon and a copolymer of a C_4 to C_7 isoolefin and a para-methylstyrene and a para-(halomethylstyrene), the blend also including nylon containing exfoliated-clays that are used as a high impact material. Further, Japanese Unexamined Application P2000-160024 to
20 *Yuichi et al.* discloses a thermoplastic elastomer composition which can be used as an air barrier. The nanocomposite in *Yuichi et al.* includes is blend similar to that disclosed in *Li et al.*

 Elastomeric nanocomposite innerliners and innertubes have also been
25 formed using a complexing agent and a rubber, where the agent is a reactive rubber having positively charged groups and a layered silicate uniformly dispersed therein. See, for example, *Kresge et al.* US 5,665,183 and 5,576,373. This approach to improving air barriers has limited usefulness due to the need for pre-formed positively charged reactive rubber components.

Nanocomposites have also been formed using non-ionic, brominated copolymers of isobutylene and para-methylstyrene, and blends of these copolymers with other polymers. See, for example, *Elspass et. al.*, US 5,807,629, and US 6,034,164. It has been found that the efficiency of clay exfoliation as determined by the relative permeability reduction, is not as high as that achieved in routes involving ionic interaction.

Thus, there is still a problem of achieving a nanocomposite suitable for an air barrier, in particular, an air barrier incorporating a halogenated elastomer such as halobutyl rubber, halogenated star branched rubbers, and copolymers (or "interpolymer") of a C₄ to C₇ isoolefin and a para-methylstyrene and a para-(halomethylstyrene) or other halogenated elastomer.

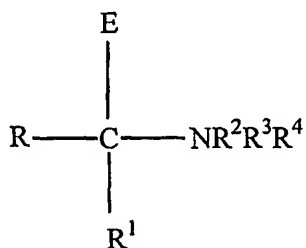
SUMMARY OF THE INVENTION

An embodiment of the present invention is a nanocomposite including halogenated elastomers of C₄ to C₇ isoolefins with, in one embodiment, a para-methylstyrene and a para-(halomethylstyrene) that have low levels of reactive bromide but which are activated toward the formation of an exfoliated nanocomposite through the addition of a functionalized additive. In another embodiment, the halogenated elastomer is a copolymer of isoolefins and multiolefins such as, for example, isoprene or cyclopentadiene. The additive is capable of reaction with the bromide sites on the polymer to form complexes which help exfoliate the clay. The clay may be exfoliated prior to mixing with the interpolymer in one embodiment, and ion exchanged with a counterion in another embodiment.

Thus, one embodiment of the invention is a nanocomposite comprising a clay, a halogenated elastomer comprising C₄ to C₇ isoolefin derived units; and a functionalized amine; wherein the functionalized amine is described by the formula NR²R³R⁴, wherein R², R³ and R⁴ are the same or different and are selected

from hydrogen, a C₁ to C₂₀ alkyl, alkene or aryl, substituted C₁ to C₂₀ alkyl, alkene or aryl, C₁ to C₂₀ aliphatic alcohol or ether, C₁ to C₂₀ carboxylic acid, nitrile, ethoxylated amine, acrylate, ester and ammonium ion.

5 Another embodiment of the invention is a nanocomposite comprising a clay and a halogenated elastomer comprising C₄ to C₇ isoolefin derived units; wherein the halogenated elastomer also comprises an amine-functionalized monomer unit described by the following group pendant to the elastomer E:



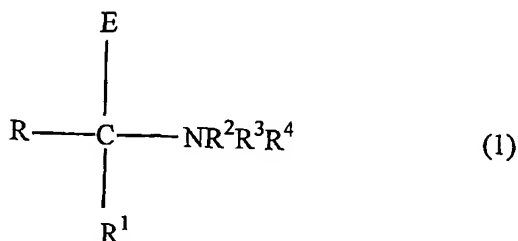
10 wherein R and R¹ are the same or different and are one of a hydrogen, a C₁ to C₇ alkyl, and primary or secondary alkyl halides; and wherein R², R³ and R⁴ are the same or different and are selected from hydrogen, a C₁ to C₂₀ alkyl, alkene or aryl, substituted C₁ to C₂₀ alkyl, alkene or aryl, C₁ to C₂₀ aliphatic alcohol or ether, C₁ to C₂₀ carboxylic acid, nitrile, ethoxylated amine, acrylate, ester and
15 ammonium ion.

DETAILED DESCRIPTION OF THE INVENTION

The present invention provides a nanocomposite including a clay, desirably an exfoliated clay, a halogenated elastomer comprising C₄ to C₇ isoolefin
20 derived units, and a functionalized amine. The functionalized amine may be first contacted or blended with the halogenated elastomer prior to blending with the clay, or may be blended in conjunction with blending with the clay. The functionalized amine desirably associates with the halogenated elastomer such that at least one or more halogens are replaced (or substituted) by the functionalized
25 amine to form an elastomer having the functionalized amine (or amine group)

pendant to the elastomer backbone. By "associate", it is meant that the functionalized amine forms a bond such as a covalent or ionic bond between the amine and the elastomer.

Thus, one embodiment of the nanocomposite can be described as a blend of one or more clays, desirably exfoliated clays, and at least one halogenated elastomer comprising C_4 to C_7 isoolefin derived units, wherein the halogenated elastomer also comprises an amine-functionalized monomer unit described by the following group pendant to the elastomer E:

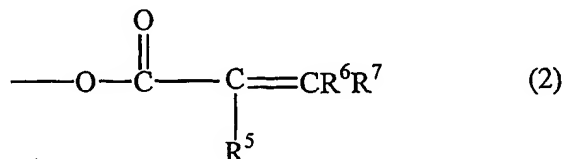


wherein in structure (1) R and R^1 are the same or different and are one of a hydrogen, a C_1 to C_7 alkyl, and primary or secondary alkyl halides; and wherein R^2 , R^3 and R^4 are the same or different and are selected from hydrogen, C_1 to C_{20} alkyl, alkenes or aryls, substituted C_1 to C_{20} alkyls, alkenes or aryls, C_1 to C_{20} aliphatic alcohols or ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ion. For example, any one of, any two of, or all of R^2 , R^3 and R^4 can be selected from an alkyl such as methyl, ethyl, butyl, propyl, hexyl, octyl, decyl, methoxy, ethoxy, propoxy; an alcohol group such as $-\text{CH}_2\text{CH}_2\text{OH}$, $-\text{CH}_2\text{CH}_2\text{CH}_2\text{OH}$, $-\text{CH}(\text{CH}_3)\text{CH}_2\text{CH}_2\text{OH}$; an acrylate as described further below in (2), or an ethoxylated amine as described further below in (3).

In one embodiment, at least one of R^2 , R^3 and R^4 are selected from alkenes or aryls, substituted C_1 to C_{20} alkyls, alkenes or aryls, C_1 to C_{20} aliphatic alcohols or ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters

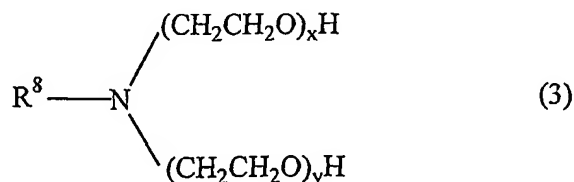
and ammonium ion. In yet another embodiment, at least one of R^2 , R^3 and R^4 are selected from C_1 to C_{20} alkenes, C_1 to C_{20} aliphatic alcohols, C_1 to C_{20} aliphatic ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions. And in yet another embodiment, at least one of R^2 , R^3 and R^4 are selected from C_1 to C_{20} aliphatic alcohols, C_1 to C_{20} aliphatic ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.

The functional groups pendant to the elastomer E can be further described by structure (2) below, wherein at least one of R^2 , R^3 and R^4 is selected from C_1 to C_{20} aliphatic alcohols or ethers, C_1 to C_{20} carboxylic acids, nitriles, esters, ammonium ions, or acrylate groups; wherein the acrylate is described by the following formula:



wherein R^5 , R^6 and R^7 are the same or different and are one of a hydrogen and a C_1 to C_7 alkyl or alkenyl. Such modifications of, for example, BIMS polymers, are disclosed by *H.C. Wang et al.* in Acrylate Ester Modifications of Isobutylene/para-methylstyrene copolymer, RUBBER WORLD (October 1994).

The ethoxylated amine functional group can be further described as having the following structure:



wherein R^8 is a C_1 to C_{20} alkyl; and wherein $x + y$ is 2, 5, 10, 15, or 50. Specific, non-limiting examples of the functionalized amine and amine functional group are dimethylaminoethylacrylate, dimethylaminomethylacrylate, N-methylamino-bis-2-propanol, N-ethylamino-bis-2-propanol, allylamine, dimethylaminoethylmethacrylate, diethylaminopropanol, diethylethanolamine, dipropylethanolamine, dibutylethanolamine, dimethylamino-1-propanol, tripropanolamine, triethanolamine, aminolauric acid, and betaine, and combinations thereof. The invention is not herein limited to the physical or derived form of the functionalized amine. For example, the amine may be a solid, liquid, suspension or solution, and may include the ionic salt or free base form of the amine.

Halogenated Elastomer

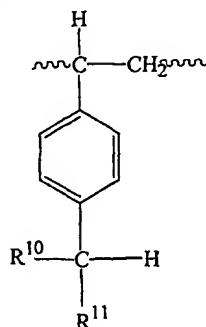
The nanocomposite of the present invention includes at least one halogenated elastomer comprising C_4 to C_7 isoolefin derived units. The isoolefin may be a C_4 to C_8 compound, in one embodiment selected from isobutylene, isobutene, 2-methyl-1-butene, 3-methyl-1-butene, 2-methyl-2-butene, and 4-methyl-1-pentene. The elastomer may also include other monomer derived units. In one embodiment, the halogenated elastomer includes at least one styrenic monomer, which may be any substituted styrene monomer unit, and desirably is selected from styrene, α -methylstyrene or an alkylstyrene (ortho, meta, or para), the alkyl selected from any C_1 to C_5 alkyl or branched chain alkyl. In a desirable embodiment, the styrenic monomer is *p*-methylstyrene. In another embodiment, the elastomer includes at least one multiolefin, which may be a C_4 to C_{14} diene, conjugated or not, in one embodiment selected from isoprene, butadiene, 2,3-dimethyl-1,3-butadiene, myrcene, 6,6-dimethyl-fulvene, hexadiene, cyclopentadiene, methylcyclopentadiene, and piperylene.

In one embodiment, the halogenated elastomer includes an isoolefin derived unit, a multiolefin derived unit, and a styrenic derived unit. In another

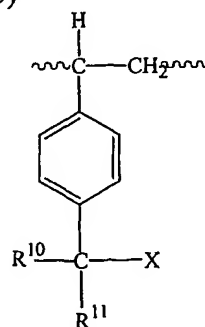
embodiment, the halogenated elastomer includes an isoolefin derived unit and a styrenic derived unit, and in yet another embodiment the halogenated elastomer includes an isoolefin derived unit and a multiolefin derived unit.

The halogenated elastomers in one embodiment of the invention are random elastomeric copolymers of a C_4 to C_7 isoolefin, such as isobutylene and a para-alkylstyrene comonomer, preferably para-methylstyrene containing at least 80%, more preferably at least 90% by weight of the para-isomer and also include functionalized interpolymers wherein at least some of the alkyl substituents groups present in the styrene monomer units contain benzylic halogen or some other functional group. In another embodiment of the invention, the interpolymers is a random elastomeric copolymer of ethylene or a C_3 to C_6 α -olefin and a para-alkylstyrene comonomer, preferably para-methylstyrene containing at least 80%, more preferably at least 90% by weight of the para-isomer and also include functionalized interpolymers wherein at least some of the alkyl substituents groups present in the styrene monomer units contain benzylic halogen or some other functional group. Preferred materials may be characterized as interpolymers containing the following monomer units randomly spaced along the polymer chain:

(4)



(5)



wherein R^{10} and R^{11} are independently hydrogen, lower alkyl, preferably C_1 to C_7 alkyl and primary or secondary alkyl halides and X is a functional group such as

halogen. Preferably R^{10} and R^{11} are each hydrogen. Up to 60 mol% of the para-substituted styrene present in the interpolymer structure may be the functionalized structure (5) above in one embodiment, and in another embodiment from 0.1 to 5 mol%. In yet another embodiment, the amount of functionalized structure (5) is from 0.4 to 1 mol%.

The functional group X may be halogen or a combination of a halogen and some other functional group such which may be incorporated by nucleophilic substitution of benzylic halogen with other groups such as carboxylic acids; carboxy salts; carboxy esters, amides and imides; hydroxy; alkoxide; phenoxide; thiolate; thioether; xanthate; cyanide; nitrile; amino and mixtures thereof. These functionalized isoolefin copolymers, their method of preparation, methods of functionalization, and cure are more particularly disclosed in US 5,162,445, and in particular, the functionalized amines as described above.

Most useful of such functionalized materials are elastomeric random interpolymers of isobutylene and para-methylstyrene containing from 0.5 to 20 mol% para-methylstyrene, wherein up to 60 mol% of the methyl substituent groups present on the benzyl ring contain a bromine or chlorine atom, preferably a bromine atom (para(bromomethylstyrene)), as well as a combination of para(bromomethylstyrene and other functional groups such as ester and ether. These halogenated elastomers are commercially available as EXXPRO™ Elastomers (ExxonMobil Chemical Company, Houston TX), and abbreviated as "BIMS".

In a preferred embodiment, the functionality is selected such that it can react or form polar bonds with functional groups present in the matrix polymer, for example, acid, amino or hydroxyl functional groups, when the polymer components are mixed at high temperatures.

These functionalized interpolymers have a substantially homogeneous compositional distribution such that at least 95% by weight of the polymer has a para-alkylstyrene content within 10% of the average para-alkylstyrene content of the polymer. Desirable interpolymers are also characterized by a narrow
5 molecular weight distribution (M_w/M_n) of less than 5, more preferably less than 2.5, a preferred viscosity average molecular weight in the range of from 200,000 up to 2,000,000 and a preferred number average molecular weight in the range of from 25,000 to 750,000 as determined by gel permeation chromatography.

10 The BIMS polymers may be prepared by a slurry polymerization of the monomer mixture using a Lewis acid catalyst, followed by halogenation, preferably bromination, in solution in the presence of halogen and a radical initiator such as heat and/or light and/or a chemical initiator and, optionally, followed by electrophilic substitution of bromine with a different functional
15 moiety.

Preferred BIMS polymers are brominated polymers that generally contain from 0.1 to 5% mole of bromomethylstyrene groups relative to the total amount of monomer derived units in the polymer. In another embodiment, the amount of
20 bromomethyl groups is from 0.2 to 3.0 mol%, and from 0.3 to 2.8 mol% in yet another embodiment, and from 0.4 to 2.5 mol% in yet another embodiment, and from 0.3 to 2.0 in yet another embodiment, wherein a desirable range may be any combination of any upper limit with any lower limit. Expressed another way, preferred copolymers contain from 0.2 to 10 wt% of bromine, based on the weight
25 of the polymer, from 0.4 to 6 wt% bromine in another embodiment, and from 0.6 to 5.6 wt% in another embodiment, are substantially free of ring halogen or halogen in the polymer backbone chain. In one embodiment of the invention, the interpolymers are a copolymer of C_4 to C_7 isoolefin derived units (or isomonoolefin), para-methylstyrene derived units and para-(halomethylstyrene) derived units,
30 wherein the para-(halomethylstyrene) units are present in the interpolymers from

0.4 to 3.0 mol% based on the total number of para-methylstyrene, and wherein the para-methylstyrene derived units are present from 3 wt% to 15 wt% based on the total weight of the polymer in one embodiment, and from 4 wt% to 10 wt% in another embodiment. In another embodiment, the para-(halomethylstyrene) is para-(bromomethylstyrene).

The halogenated elastomer useful in the present invention may also include a halogenated butyl rubber component. As used herein, "halogenated butyl rubber" refers to both butyl rubber and so-called "star-branched" butyl rubber, described below. In one embodiment of the invention, the halogenated rubber component is a halogenated copolymer of a C₄ to C₇ isoolefin and a multiolefin. In another embodiment, the halogenated rubber component is a blend of a polydiene or block copolymer, and a copolymer of a C₄ to C₇ isoolefin and a conjugated, or a "star-branched" butyl polymer. The halogenated butyl polymer useful in the present invention can thus be described as a halogenated elastomer comprising C₄ to C₇ isoolefin derived units, multiolefin derived units, and halogenated multiolefin derived units, and includes both "halogenated butyl rubber" and so called "halogenated star-branched" butyl rubber.

In one embodiment, the halogenated butyl rubber is brominated butyl rubber, and in another embodiment is chlorinated butyl rubber. General properties and processing of halogenated butyl rubbers is described in THE VANDERBILT RUBBER HANDBOOK 105-122 (Robert F. Ohm ed., R.T. Vanderbilt Co., Inc. 1990), and in RUBBER TECHNOLOGY 311-321 (Maurice Morton ed., Chapman & Hall 1995). Butyl rubbers, halogenated butyl rubbers, and star-branched butyl rubbers are described by *Edward Kresge and H.C. Wang* in 8 KIRK-OTHMER ENCYCLOPEDIA OF CHEMICAL TECHNOLOGY 934-955 (John Wiley & Sons, Inc. 4th ed. 1993).

The halogenated rubber component of the present invention includes, but is not limited to, brominated butyl rubber, chlorinated butyl rubber, star-branched polyisobutylene rubber, star-branched brominated butyl (polyisobutylene/isoprene copolymer) rubber; isobutylene-bromomethylstyrene copolymers such as isobutylene/meta-bromomethylstyrene, isobutylene/para-bromomethylstyrene, isobutylene/chloromethylstyrene, halogenated isobutylene cyclopentadiene, and isobutylene/para-chloromethylstyrene, and the like halomethylated aromatic interpolymers as in US 4,074,035 and US 4,395,506; isoprene and halogenated isobutylene copolymers, polychloroprene, and the like, and mixtures of any of the above. Some embodiments of the halogenated rubber component are also described in US 4,703,091 and 4,632,963.

More particularly, in one embodiment of the brominated rubber component of the invention, a halogenated butyl rubber is used. The halogenated butyl rubber is produced from the halogenation of butyl rubber. Preferably, the olefin polymerization feeds employed in producing the halogenated butyl rubber of the invention are those olefinic compounds conventionally used in the preparation of butyl-type rubber polymers. The butyl polymers are prepared by reacting a comonomer mixture, the mixture having at least (1) a C_4 to C_7 isoolefin monomer component such as isobutylene with (2) a multiolefin, or conjugated diene, monomer component. The isoolefin is in a range from 70 to 99.5 wt% by weight of the total comonomer mixture in one embodiment, and 85 to 99.5 wt% in another embodiment. The conjugated diene component in one embodiment is present in the comonomer mixture from 30 to 0.5 wt% in one embodiment, and from 15 to 0.5 wt% in another embodiment. In yet another embodiment, from 8 to 0.5 wt% of the comonomer mixture is conjugated diene.

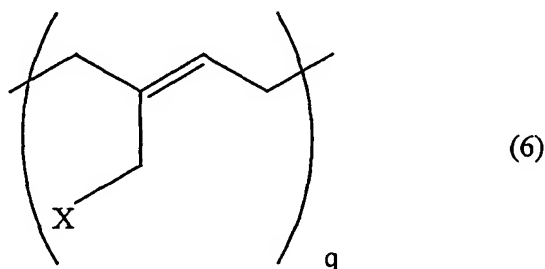
The isoolefin is a C_4 to C_6 compound such as isobutylene, isobutene 2-methyl-1-butene, 3-methyl-1-butene, 2-methyl-2-butene, and 4-methyl-1-pentene. The multiolefin is a C_4 to C_{14} conjugated diene such as isoprene, butadiene, 2,3-

dimethyl-1,3-butadiene, myrcene, 6,6-dimethyl-fulvene, cyclopentadiene, hexadiene and piperylene. One embodiment of the butyl rubber polymer of the invention is obtained by reacting 92 to 99.5 wt% of isobutylene with 0.5 to 8 wt% isoprene, or reacting 95 to 99.5 wt% isobutylene with from 0.5 wt% to 5.0 wt% isoprene in yet another embodiment.

Halogenated butyl rubber is produced by the halogenation of the butyl rubber product described above. Halogenation can be carried out by any means, and the invention is not herein limited by the halogenation process. Methods of halogenating polymers such as butyl polymers are disclosed in US 2,631,984, 3,099,644, 4,554,326, 4,681,921, 4,650,831, 4,384,072, 4,513,116 and 5,681,901. In one embodiment, the halogen is in the so called II and III structures as discussed in, for example, RUBBER TECHNOLOGY at 298-299 (1995). In one embodiment, the butyl rubber is halogenated in hexane diluent at from 40 to 60°C using bromine (Br₂) or chlorine (Cl₂) as the halogenation agent. The halogenated butyl rubber has a Mooney Viscosity of from 20 to 70 (ML 1+8 at 125°C) in one embodiment, and from 25 to 55 in another embodiment. The halogen wt% is from 0.1 to 10 wt% based in on the weight of the halogenated butyl rubber in one embodiment, and from 0.5 to 5 wt% in another embodiment. In yet another embodiment, the halogen wt% of the halogenated butyl rubber is from 1 to 2.2 wt%.

In another embodiment, the halogenated butyl or star-branched butyl rubber may be halogenated such that the halogenation is primarily allylic in nature. This is typically achieved by such means as free radical bromination or free radical chlorination, or by such methods as secondary treatment of electrophilically halogenated rubbers, such as by heating the rubber, to form the allylic halogenated butyl and star-branched butyl rubber. Common methods of forming the allylic halogenated polymer are disclosed by *Gardner et al.* in US 4,632,963; US 4,649,178; US 4,703,091. Thus, in one embodiment of the

invention, the halogenated butyl rubber is such that the halogenated multiolefin units are primary allylic halogenated units, and wherein the primary allylic configuration is present to at least 20 mol% (relative to the total amount of halogenated multiolefin) in one embodiment, and at least 30 mol% in another embodiment. This arrangement can be described as follows (6), wherein X is a halogen, desirably chlorine or bromine, and q is at least 20 mol% based on the total moles of halogen in one embodiment, and at least 30 mole% in another embodiment, and from 25 mol% to 90 mol% in yet another embodiment:



A commercial embodiment of the halogenated butyl rubber of the present invention is Bromobutyl 2222 (ExxonMobil Chemical Company). Its Mooney Viscosity is from 27 to 37 (ML 1+8 at 125°C, ASTM 1646, modified), and the bromine content is from 1.8 to 2.2 wt% relative to the Bromobutyl 2222. Further, cure characteristics of Bromobutyl 2222 are as follows: MH is from 28 to 40 dN·m, ML is from 7 to 18 dN·m (ASTM D2084, modified). Another commercial embodiment of the halogenated butyl rubber is Bromobutyl 2255 (ExxonMobil Chemical Company). Its Mooney Viscosity is from 41 to 51 (ML 1+8 at 125°C, ASTM 1646, modified), and the bromine content is from 1.8 to 2.2 wt%. Further, cure characteristics of Bromobutyl 2255 are as follows: MH is from 34 to 48 dN·m, ML is from 11 to 21 dN·m (ASTM D2084, modified). The invention is not limited to the commercial source of any of the halogenated rubber components.

In another embodiment of the brominated rubber component of the invention, a branched or "star-branched" halogenated butyl rubber is used. In one

embodiment, the star-branched halogenated butyl rubber ("SBHR") is a composition of a butyl rubber, either halogenated or not, and a polydiene or block copolymer, either halogenated or not. The halogenation process is described in detail in US 4,074,035, 5,071,913, 5,286,804, 5,182,333 and 6,228,978. The invention is not limited by the method of forming the SBHR. The polydienes/block copolymer, or branching agents (hereinafter "polydienes"), are typically cationically reactive and are present during the polymerization of the butyl or halogenated butyl rubber, or can be blended with the butyl or halogenated butyl rubber to form the SBHR. The branching agent or polydiene can be any suitable branching agent, and the invention is not limited to the type of polydiene used to make the SBHR.

In one embodiment, the SBHR is typically a composition of the butyl or halogenated butyl rubber as described above and a copolymer of a polydiene and a partially hydrogenated polydiene selected from the group including styrene, polybutadiene, polyisoprene, polypiperylene, natural rubber, styrene-butadiene rubber, ethylene-propylene diene rubber, styrene-butadiene-styrene and styrene-isoprene-styrene block copolymers. These polydienes are present, based on the monomer wt%, greater than 0.3 wt% in one embodiment, and from 0.3 to 3 wt% in another embodiment, and from 0.4 to 2.7 wt% in yet another embodiment.

A commercial embodiment of the SBHR of the present invention is Bromobutyl 6222 (ExxonMobil Chemical Company), having a Mooney Viscosity (ML 1+8 at 125°C, ASTM 1646, modified) of from 27 to 37, and a bromine content of from 2.2 to 2.6 wt% relative to the SBHR. Further, cure characteristics of Bromobutyl 6222 are as follows: MH is from 24 to 38 dN·m, ML is from 6 to 16 dN·m (ASTM D2084, modified).

The halogenated rubber component is present in the blend of the invention from 10 to 90 phr in one embodiment, from 20 to 80 phr in another embodiment,

and from 30 to 70 phr in yet another embodiment, wherein a desirable range may be any combination of any upper phr limit with any lower phr limit.

Clays

5 The nanocomposites of the present invention may include at least one halogenated elastomer above blended by any suitable means with at least one swellable clay, either pre-mixed with an exfoliating additive or not. Swellable layered clay materials suitable for the purposes of this invention include natural or synthetic phyllosilicates, particularly smectic clays such as montmorillonite, nontronite, beidellite, volkonskoite, laponite, hectorite, saponite, sauconite, 10 magadite, kenyaite, stevensite and the like, as well as vermiculite, halloysite, aluminate oxides, hydrotalcite and the like. These layered clays generally comprise particles containing a plurality of silicate platelets having a thickness of 8-12Å tightly bound together at interlayer spacings of 4Å or less, and contain 15 exchangeable cations such as Na⁺, Ca⁺², K⁺ or Mg⁺² present at the interlayer surfaces.

 The layered clay may be intercalated and exfoliated by treatment with organic molecules (swelling or exfoliating "agents" or "additives") capable of 20 undergoing ion exchange reactions with the cations present at the interlayer surfaces of the layered silicate. Suitable exfoliating additives include cationic surfactants such as ammonium ion, alkylamines or alkylammonium ion (primary, secondary, tertiary and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides. Desirable 25 amine compounds (or the corresponding ammonium ion) are those with the structure R¹²R¹³R¹⁴N, wherein R¹², R¹³, and R¹⁴ are C₁ to C₃₀ alkyls or alkenes in one embodiment, C₁ to C₂₀ alkyls or alkenes in another embodiment, which may be the same or different. In one embodiment, the exfoliating agent is a so called long chain tertiary amine, wherein at least R¹² is a C₁₄ to C₂₀ alkyl or alkene.

Another class of exfoliating additives include those which can be covalently bonded to the interlayer surfaces. These include polysilanes of the structure $-\text{Si}(\text{R}^{15})_2\text{R}^{16}$ where R^{15} is the same or different at each occurrence and is selected from alkyl, alkoxy or oxysilane and R^{16} is an organic radical compatible with the matrix polymer of the composite.

Other suitable exfoliating additives include protonated amino acids and salts thereof containing 2-30 carbon atoms such as 12-aminododecanoic acid, epsilon-caprolactam and like materials. Suitable swelling agents and processes for intercalating layered silicates are disclosed in US 4,472,538, 4,810,734, 4,889,885 as well as WO92/02582.

In a preferred embodiment of the invention, the exfoliating additive or additives are capable of reaction with the halogen sites on the interpolymer to form complexes which help exfoliate the clay. In one embodiment, the additive includes all primary, secondary and tertiary amines and phosphines; alkyl and aryl sulfides and thiols; and their polyfunctional versions. Desirable additives include: long-chain tertiary amines such as N,N-dimethyl-octadecylamine, N,N-di-octadecyl-methylamine, so called dihydrogenated tallowalkyl-methylamine and the like, and amine-terminated polytetrahydrofuran; long-chain thiol and thiosulfate compounds like hexamethylene sodium thiosulfate.

The exfoliating additive such as described herein is present in the composition in an amount to achieve optimal air retention as measured by the permeability testing described herein. For example, the additive may be present from 0.1 to 20 phr in one embodiment, and from 0.2 to 15 phr in yet another embodiment, and from 0.3 to 10 phr in yet another embodiment. The exfoliating additive may be added to the composition at any stage; for example, the additive may be added to the interpolymer, followed by addition of the clay, or may be added to the interpolymer and clay mixture; or the additive may be first blended

with the clay, followed by blending with the interpolmer in yet another embodiment.

In another embodiment of the invention, improved interpolmer impermeability is achieved by the presence of at least one polyfunctional curative. An embodiment of such polyfunctional curatives can be described by the formula $Z-R^{17}-Z'$, wherein R^{17} is one of a C_1 to C_{15} alkyl, C_2 to C_{15} alkenyl, and C_6 to C_{12} cyclic aromatic moiety, substituted or unsubstituted; and Z and Z' are the same or different and are one of a thiosulfate group, mercapto group, aldehyde group, carboxylic acid group, peroxide group, alkenyl group, or other similar group that is capable of crosslinking, either intermolecularly or intramolecularly, one or more strands of a polymer having reactive groups such as unsaturation. So-called bis-thiosulfate compounds are an example of a desirable class of polyfunctional compounds included in the above formula. Non-limiting examples of such polyfunctional curatives are as hexamethylene bis(sodium thiosulfate) and hexamethylene bis(cinnamaldehyde), and others are well known in the rubber compounding arts. These and other suitable agents are disclosed in, for example, the BLUE BOOK, MATERIALS, COMPOUNDING INGREDIENTS, MACHINERY AND SERVICES FOR RUBBER (Don. R. Smith, ed., Lippincott & Petto Inc. 2001). The polyfunctional curative, if present, may be present in the composition from 0.1 to 8 phr in one embodiment, and from 0.2 to 5 phr in yet another embodiment.

Treatment with the swelling agents described above results in intercalation or "exfoliation" of the layered platelets as a consequence of a reduction of the ionic forces holding the layers together and introduction of molecules between layers which serve to space the layers at distances of greater than 4\AA , preferably greater than 9\AA . This separation allows the layered silicate to more readily sorb polymerizable monomer material and polymeric material between the layers and facilitates further delamination of the layers when the intercalate is shear mixed

with matrix polymer material to provide a uniform dispersion of the exfoliated layers within the polymer matrix.

5 The amount of clay or exfoliated clay incorporated in the nanocomposites in accordance with this invention is sufficient to develop an improvement in the mechanical properties or barrier properties of the nanocomposite, for example, tensile strength or oxygen permeability. Amounts generally will range from 0.5 to 10 wt% in one embodiment, and from 1 to 5 wt% in another embodiment, based on the polymer content of the nanocomposite. Expressed in parts per hundred 10 rubber, the clay or exfoliated clay may be present from 1 to 30 phr in one embodiment, and from 5 to 20 phr in another embodiment. In one embodiment, the exfoliated clay is an alkylamine-exfoliated clay.

Secondary Rubber Component

15 A secondary rubber, or "general purpose rubber" component may be present in compositions and end use articles of the present invention. These rubbers include, but are not limited to, natural rubbers, polyisoprene rubber, poly(styrene-*co*-butadiene) rubber (SBR), polybutadiene rubber (BR), poly(isoprene-*co*-butadiene) rubber (IBR), styrene-isoprene-butadiene rubber (SIBR), ethylene-propylene rubber (EPM), ethylene-propylene-diene rubber (EPDM), polysulfide, nitrile rubber, propylene oxide polymers, star-branched 20 butyl rubber and halogenated star-branched butyl rubber, brominated butyl rubber, chlorinated butyl rubber, star-branched polyisobutylene rubber, star-branched brominated butyl (polyisobutylene/isoprene copolymer) rubber; poly(isobutylene-*co-p*-methylstyrene) and halogenated poly(isobutylene-*co-p*-methylstyrene), such 25 as, for example, terpolymers of isobutylene derived units, *p*-methylstyrene derived units, and *p*-bromomethylstyrene derived units, and mixtures thereof.

30 A desirable embodiment of the secondary rubber component present is natural rubber. Natural rubbers are described in detail by *Subramaniam* in

RUBBER TECHNOLOGY 179-208 (Maurice Morton, Chapman & Hall 1995). Desirable embodiments of the natural rubbers of the present invention are selected from Malaysian rubber such as SMR CV, SMR 5, SMR 10, SMR 20, and SMR 50 and mixtures thereof, wherein the natural rubbers have a Mooney viscosity at 100°C (ML 1+4) of from 30 to 120, more preferably from 40 to 65. The Mooney viscosity test referred to herein is in accordance with ASTM D-1646.

Polybutadiene (BR) rubber is another desirable secondary rubber useful in the composition of the invention. The Mooney viscosity of the polybutadiene rubber as measured at 100°C (ML 1+4) may range from 35 to 70, from 40 to about 65 in another embodiment, and from 45 to 60 in yet another embodiment. Some commercial examples of these synthetic rubbers useful in the present invention are NATSYN™ (Goodyear Chemical Company), and BUDENE™ 1207 or BR 1207 (Goodyear Chemical Company). A desirable rubber is high cis-polybutadiene (cis-BR). By "cis-polybutadiene" or "high cis-polybutadiene", it is meant that 1,4-cis polybutadiene is used, wherein the amount of cis component is at least 95%. An example of high cis-polybutadiene commercial products used in the composition BUDENE™ 1207.

Rubbers of ethylene and propylene derived units such as EPM and EPDM are also suitable as secondary rubbers. Examples of suitable comonomers in making EPDM are ethylidene norbornene, 1,4-hexadiene, dicyclopentadiene, as well as others. These rubbers are described in RUBBER TECHNOLOGY 260-283 (1995). A suitable ethylene-propylene rubber is commercially available as VISTALON™ (ExxonMobil Chemical Company, Houston TX).

In another embodiment, the secondary rubber is a halogenated rubber as part of the terpolymer composition. The halogenated butyl rubber is brominated butyl rubber, and in another embodiment is chlorinated butyl rubber. General properties and processing of halogenated butyl rubbers is described in THE

VANDERBILT RUBBER HANDBOOK 105-122 (Robert F. Ohm ed., R.T. Vanderbilt Co., Inc. 1990), and in RUBBER TECHNOLOGY 311-321 (1995). Butyl rubbers, halogenated butyl rubbers, and star-branched butyl rubbers are described by Edward Kresge and H.C. Wang in 8 KIRK-OTHMER ENCYCLOPEDIA OF CHEMICAL TECHNOLOGY 934-955 (John Wiley & Sons, Inc. 4th ed. 1993).

The secondary rubber component of the present invention includes, but is not limited to at least one or more of brominated butyl rubber, chlorinated butyl rubber, star-branched polyisobutylene rubber, star-branched brominated butyl (polyisobutylene/isoprene copolymer) rubber; halogenated poly(isobutylene-co-*p*-methylstyrene), such as, for example, terpolymers of isobutylene derived units, *p*-methylstyrene derived units, and *p*-bromomethylstyrene derived units (BrIBMS), and the like halomethylated aromatic interpolymers as in US5,162,445; US4,074,035; and US4,395,506; halogenated isoprene and halogenated isobutylene copolymers, polychloroprene, and the like, and mixtures of any of the above. Some embodiments of the halogenated rubber component are also described in US4,703,091 and US4,632,963.

In one embodiment of the invention, a so called semi-crystalline copolymer ("SCC") is present as the secondary "rubber" component. Semi-crystalline copolymers are described in WO00/69966. Generally, the SCC is a copolymer of ethylene or propylene derived units and α -olefin derived units, the α -olefin having from 4 to 16 carbon atoms in one embodiment, and in another embodiment the SCC is a copolymer of ethylene derived units and α -olefin derived units, the α -olefin having from 4 to 10 carbon atoms, wherein the SCC has some degree of crystallinity. In a further embodiment, the SCC is a copolymer of 1-butene derived units and another α -olefin derived unit, the other α -olefin having from 5 to 16 carbon atoms, wherein the SCC also has some degree of crystallinity. The SCC can also be a copolymer of ethylene and styrene.

The secondary rubber component of the elastomer composition may be present in a range from up to 90 phr in one embodiment, from up to 50 phr in another embodiment, from up to 40 phr in another embodiment, and from up to 30 phr in yet another embodiment. In yet another embodiment, the secondary rubber is present from at least 2 phr, and from at least 5 phr in another embodiment, and from at least 5 phr in yet another embodiment, and from at least 10 phr in yet another embodiment. A desirable embodiment may include any combination of any upper phr limit and any lower phr limit. For example, the secondary rubber, either individually or as a blend of rubbers such as, for example NR and BR, may be present from 5 phr to 90 phr in one embodiment, and from 10 to 80 phr in another embodiment, and from 30 to 70 phr in yet another embodiment, and from 40 to 60 phr in yet another embodiment, and from 5 to 50 phr in yet another embodiment, and from 5 to 40 phr in yet another embodiment, and from 20 to 60 phr in yet another embodiment, and from 20 to 50 phr in yet another embodiment, the chosen embodiment depending upon the desired end use application of the composition.

Thermoplastic

The composition of this invention may optionally include a thermoplastic resin. The thermoplastic engineering resins suitable for practice of the present invention may be used singly or in combination and are resins containing nitrogen, oxygen, halogen, sulfur or other groups capable of interacting with an aromatic functional groups such as halogen or acidic groups. The resins are present in the nanocomposite from 30 to 90 wt% of the nanocomposite in one embodiment, and from 40 to 80 wt% in another embodiment, and from 50 to 70 wt% in yet another embodiment. In yet another embodiment, the resin is present at a level of greater than 40 wt% of the nanocomposite, and greater than 60 wt% in another embodiment.

Suitable engineering resins include resins selected from the group consisting of polyamides, polyimides, polycarbonates, polyesters, polysulfones, polylactones, polyacetals, acrylonitrile-butadiene-styrene resins (ABS), polyphenyleneoxide (PPO), polyphenylene sulfide (PPS), polystyrene, styrene-acrylonitrile resins (SAN), styrene maleic anhydride resins (SMA), aromatic polyketones (PEEK, PED, and PEKK) and mixtures thereof, and optionally, polyolefins.

Suitable thermoplastic polyamides (nylons) comprise crystalline or resinous, high molecular weight solid polymers including copolymers and terpolymers having recurring amide units within the polymer chain. Polyamides may be prepared by polymerization of one or more epsilon lactams such as caprolactam, pyrrolidione, lauryllactam and aminoundecanoic lactam, or amino acid, or by condensation of dibasic acids and diamines. Both fiber-forming and molding grade nylons are suitable. Examples of such polyamides are polycaprolactam (nylon-6), polylauryllactam (nylon-12), polyhexamethylenedipamide (nylon-6,6) polyhexamethyleneazelaamide (nylon-6,9), polyhexamethylenesadecanamide (nylon-6,10), polyhexamethyleneisophthalamide (nylon-6, IP) and the condensation product of 11-amino-undecanoic acid (nylon-11). Additional examples of satisfactory polyamides (especially those having a softening point below 275°C) are described in 16 ENCYCLOPEDIA OF CHEMICAL TECHNOLOGY 1-105 (John Wiley & Sons 1968), CONCISE ENCYCLOPEDIA OF POLYMER SCIENCE AND ENGINEERING 748-761 (John Wiley & Sons, 1990), and 10 ENCYCLOPEDIA OF POLYMER SCIENCE AND TECHNOLOGY 392-414 (John Wiley & Sons 1969). Commercially available thermoplastic polyamides may be advantageously used in the practice of this invention, with linear crystalline polyamides having a softening point or melting point between 160 and 260°C being preferred.

Suitable thermoplastic polyesters which may be employed include the polymer reaction products of one or a mixture of aliphatic or aromatic polycarboxylic acids esters of anhydrides and one or a mixture of diols. Examples of satisfactory polyesters include poly(trans-1,4-cyclohexylene), C₂₋₆ alkane dicarboxylates such as poly(trans-1,4-cyclohexylene succinate) and poly (trans-1,4-cyclohexylene adipate); poly (cis or trans-1,4-cyclohexanedimethylene) alkanedicarboxylates such as poly(cis-1,4-cyclohexane-di-methylene) oxlate and poly-(cis-1,4-cyclohexane-di-methylene) succinate, poly (C₂₋₄ alkylene terephthalates) such as polyethyleneterephthalate and polytetramethylene-terephthalate, poly (C₂₋₄ alkylene isophthalates such as polyethyleneisophthalate and polytetramethylene-isophthalate and like materials. Preferred polyesters are derived from aromatic dicarboxylic acids such as naphthalenic or phthalic acids and C₂ to C₄ diols, such as polyethylene terephthalate and polybutylene terephthalate. Preferred polyesters will have a melting point in the range of 160°C to 260°C.

Poly(phenylene ether) (PPE) thermoplastic engineering resins which may be used in accordance with this invention are well known, commercially available materials produced by the oxidative coupling polymerization of alkyl substituted phenols. They are generally linear, amorphous polymers having a glass transition temperature in the range of 190°C to 235°C. These polymers, their method of preparation and blends with polystyrene are further described in US 3,383,435.

Other thermoplastic resins which may be used include the polycarbonate analogs of the polyesters described above such as segmented poly (ether co-phthalates); polycaprolactone polymers; styrene resins such as copolymers of styrene with less than 50 mol% of acrylonitrile (SAN) and resinous copolymers of styrene, acrylonitrile and butadiene (ABS); sulfone polymers such as polyphenyl sulfone; copolymers and homopolymers of ethylene and C₂ to C₈ α -olefins, in one embodiment a homopolymer of propylene derived units, and in another

embodiment a random copolymer or block copolymer of ethylene derived units and propylene derived units, and like engineering resins as are known in the art.

5 The composition of the invention may also include one or more filler components such as calcium carbonate, clay, mica, silica and silicates, talc, titanium dioxide, and carbon black. In one embodiment, the filler is carbon black or modified carbon black. The preferred filler is semi-reinforcing grade carbon black present at a level of from 10 to 150 phr of the blend, more preferably from 30 to 120 phr. Useful grades of carbon black as described in RUBBER
10 TECHNOLOGY 59-85 (1995) range from N110 to N990. More desirably, embodiments of the carbon black useful in, for example, tire treads are N229, N351, N339, N220, N234 and N110 provided in ASTM (D3037, D1510, and D3765). Embodiments of the carbon black useful in, for example, sidewalls in tires, are N330, N351, N550, N650, N660, and N762. Embodiments of the carbon
15 black useful in, for example, innerliners for tires are N550, N650, N660, N762, and N990.

The composition of this invention may optionally include curative systems which are capable of curing the functionalized elastomeric copolymer component
20 of the blend to provide vulcanizable compositions. Suitable curative systems for the elastomeric copolymer component of the present invention include organic peroxides, zinc oxide in combination with zinc stearate or stearic acid and, optionally, one or more of the following accelerators or vulcanizing agents: Permalux (di-ortho-tolylguanidine salt of dicatechol borate), HVA-2 (m-phenylene bis maleimide), Zisnet (2, 4, 6- trimercapto- 5 triazine), ZDEDC (zinc
25 diethyl dithiocarbamate) and other dithiocarbamates, Tetrone A (dipenta-methylene thiuram hexasulfide), Vultac-5 (alkylated phenol disulfide), SP1045 (phenol formaldehyde resin), SP1056 (brominated alkyl phenol formaldehyde resin), DPPD. (diphenyl phenylene diamine), salicyclic acid (o-hydroxy benzoic
30 acid), wood rosin (abietic acid), and TMTDS (tetramethyl thiuram disulfide) in

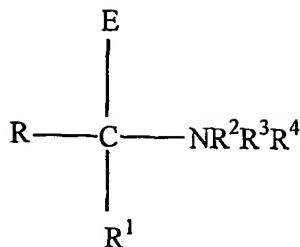
combination with sulfur. The composition may also be cured using ultraviolet light or electron irradiation.

5 The compositions of the invention may also contain other conventional additives such as dyes, pigments, antioxidants, heat and light stabilizers, plasticizers, oils and other ingredients as known in the art.

10 Blending of the components may be carried out by combining the polymer components and the clay in the form of an intercalate in any suitable mixing device such as a Banbury™ mixer, Brabender™ mixer or preferably a mixer/extruder and mixing at temperatures in the range of 120° C up to 300° C under conditions of shear sufficient to allow the clay intercalate to exfoliate and become uniformly dispersed within the polymer to form the nanocomposite.

15 The composition of this invention may be extruded, compression molded, blow molded or injection molded into various shaped articles including fibers, films, industrial parts such as automotive parts, appliance housings, consumer products, packaging and the like. The resulting articles exhibit both high impact strength and low vapor permeability. In particular, the composition described
20 herein is useful for air barriers such as bladders, and automotive (including truck, commercial and/or passenger) or aircraft innerliners and innertubes.

25 One embodiment of the present invention is a nanocomposite comprising a clay and a halogenated elastomer comprising C₄ to C₇ isoolefin derived units; wherein the halogenated elastomer also comprises an amine-functionalized monomer unit described by the following group pendant to the elastomer E:

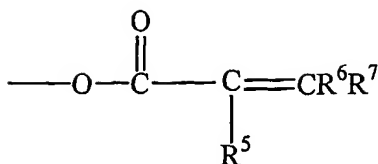


wherein R and R¹ are the same or different and are one of a hydrogen, C₁ to C₇ alkyls, and primary or secondary alkyl halides; and wherein R², R³ and R⁴ are the same or different and are selected from hydrogen, C₁ to C₂₀ alkyls, alkenes or aryls, substituted C₁ to C₂₀ alkyls, alkenes or aryls, C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions. In a desirable embodiment, at least one of R², R³ and R⁴ are selected from C₁ to C₂₀ alkenes, C₁ to C₂₀ aliphatic alcohols, C₁ to C₂₀ aliphatic ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.

In one embodiment, the halogenated elastomer E comprises C₄ to C₇ isoolefin derived units, para-methylstyrene derived units and a para-(halomethylstyrene) derived units.

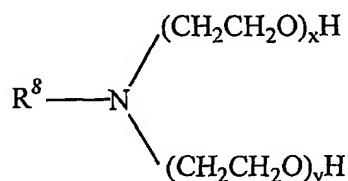
In another embodiment, the halogenated elastomer E comprises C₄ to C₇ isoolefin derived units, multiolefin derived units, and halogenated multiolefin derived units.

The functional group pendant to the elastomer E can be further described as functionalized amine, wherein at least one of R², R³ and R⁴ is selected from C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, esters, ammonium ions, or acrylate groups; wherein the acrylate is described by the following formula:



wherein R^5 , R^6 and R^7 are the same or different and are one of a hydrogen and a C_1 to C_7 alkyl or alkenyl.

5 In another embodiment, the amine functional group is selected from ethoxylated amines having the following structure:



wherein R^8 is a C_1 to C_{20} alkyl; and wherein $x + y$ is 2, 5, 10, 15, or 50.

10

In another embodiment, the amine functional group is selected from dimethylaminoethylacrylate, dimethylaminomethylacrylate, N-methylamino-bis-2-propanol, N-ethylamino-bis-2-propanol, dimethylaminoethylmethacrylate, diethylaminopropanol, diethylethanolamine, dimethylamino-1-propanol, tripropanolamine, triethanolamine, aminolauric acid, and betaine, and combinations thereof.

15

The amine-functionalized derived unit may be present on the halogenated elastomer from 0.01 wt% to 10 wt% of the nanocomposite in one embodiment, and from 0.1 wt% to 8 wt% in another embodiment, and from 0.2 to 6 wt% in yet another embodiment, wherein a desirable range may be any combination of any upper wt% limit with any lower wt% limit.

20

The nanocomposite may further include one or more polyfunctional curatives selected from structures described by the formula $Z-R^{17}-Z'$, wherein R^{17} is one of a C_1 to C_{15} alkyl, C_2 to C_{15} alkenyl, and C_6 to C_{12} cyclic aromatic moiety, substituted or unsubstituted; and Z and Z' are the same or different and are one of a thiosulfate group, mercapto group, aldehyde group, carboxylic acid group, peroxide group, alkenyl group, or other similar group that is capable of crosslinking, either intermolecularly or intramolecularly, one or more strands of a polymer having reactive groups such as unsaturation.

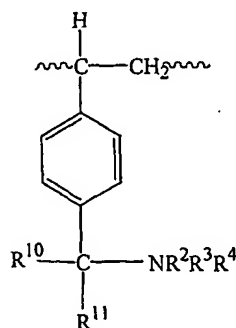
The nanocomposite may also comprise other materials such as fillers, process oils, antioxidants, pigments, etc. Nonlimiting examples of fillers include carbon black, modified carbon black, silica, precipitated silica, and blends thereof. Curing agents may also be present in the composition and air barriers of the invention, including but not limited to zinc, zinc stearate, fatty acids (*e.g.*, stearic acid), sulfur, and mixtures thereof.

In yet another embodiment of the invention, the clay is an exfoliated clay, wherein the exfoliated clay has been contacted (*e.g.*, blended as by a Brabender mixer) with an exfoliating agent. The exfoliating agent may be selected from such agents as ammonium ion, alkylamines, alkylammonium ion (primary, secondary, tertiary and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides and blends thereof. The clay is present from 0.1 wt% to 50 wt% of the nanocomposite composition (based on the weight of the halogenated elastomer and amine) in one embodiment, and from 0.2 to 40 wt% in another embodiment, and from 1 to 30 wt% in yet another embodiment, and from 10 to 40 wt% in yet another embodiment, and from 0.5 wt% to 10 wt% in yet another embodiment, wherein a desirable range of clay or exfoliated clay in the nanocomposite is any combination of any upper wt% limit with any lower wt% limit.

In yet another embodiment, the nanocomposite includes a secondary rubber selected from natural rubber, polybutadiene rubber, nitrile rubber, silicon rubber, polyisoprene rubber, poly(styrene-*co*-butadiene) rubber, poly(isoprene-*co*-butadiene) rubber, styrene-isoprene-butadiene rubber, ethylene-propylene rubber, brominated butyl rubber, chlorinated butyl rubber, halogenated isoprene, halogenated isobutylene copolymers, polychloroprene, star-branched polyisobutylene rubber, star-branched brominated butyl rubber, poly(isobutylene-*co*-isoprene) rubber; halogenated poly(isobutylene-*co*-*p*-methylstyrene) and mixtures thereof.

Alternately, the present invention can be described as a nanocomposite comprising a clay, a halogenated elastomer comprising C₄ to C₇ isolefin derived units; and a functionalized amine; wherein the functionalized amine is described by the formula NR²R³R⁴, wherein R², R³ and R⁴ are the same or different and are selected from hydrogen, a C₁ to C₂₀ alkyl, alkene or aryl, substituted C₁ to C₂₀ alkyl, alkene or aryl, C₁ to C₂₀ aliphatic alcohol or ether, C₁ to C₂₀ carboxylic acid, nitrile, ethoxylated amine, acrylate, ester and ammonium ion. The functional groups and optional components are as described above.

In yet another alternative embodiment, the nanocomposite can be described as a blend of a clay, and an interpolymers; wherein the interpolymers comprises amine-functionalized monomer unit described by the following:



wherein R^{10} and R^{11} are the same or different and are one of a hydrogen, a C_1 to C_7 alkyl, and primary or secondary alkyl halides; and wherein R^2 , R^3 and R^4 are the same or different and are selected from hydrogen, C_1 to C_{20} alkyls, alkenes or aryls, substituted C_1 to C_{20} alkyls, alkenes or aryls, C_1 to C_{20} aliphatic alcohols or ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions. The functional groups and optional components are as described above in the indicated amounts.

The present invention also includes a method of forming a nanocomposite comprising combining clay; a halogenated elastomer comprising C_4 to C_7 isoolefin derived units and, a functionalized amine; wherein the functionalized amine is described by the formula $NR^2R^3R^4$, wherein R^2 , R^3 and R^4 are the same or different and are selected from hydrogen, a C_1 to C_{20} alkyl, alkene or aryl, substituted C_1 to C_{20} alkyl, alkene or aryl, C_1 to C_{20} aliphatic alcohol or ether, C_1 to C_{20} carboxylic acid, nitrile, acrylate, ester and ammonium ion.

In one embodiment, the elastomer and functionalized amine are combined in a first step, followed by blending with at least one clay. In another embodiment, the elastomer, functionalized amine, and clay are combined in a single blending step. In yet another embodiment, the clay is pre-treated prior to blending with the interpolpolymer; the interpolpolymer, clay and exfoliating additive are added together (hence, not pre-treated) in yet another embodiment. The final composition is formable and curable into such articles as air barriers, in particular, innertubes and innerliners.

The following examples are illustrative of the invention.

Test Methods & Examples

Permeability Testing. All specimens were compression molded with slow cooling to provide defect free pads. A compression and curing press was used for rubber samples. Typical thickness of a compression molded pad is around 15 mil.

using an Arbor press, 2" diameter disks were then punched out from molded pads for permeability testing. These disks were conditioned in a vacuum oven at 60°C overnight prior to the measurement. The oxygen permeation measurements were done using a Mocon OX-TRAN 2/61 permeability tester at 40°C under the principle of *R. A. Pasternak et. al.* in 8 JOURNAL OF POLYMER SCIENCE: PART A-2 467 (1970). Disks thus prepared were mounted on a template and sealed with a vacuum grease. 10 psi nitrogen was kept on one side of the disk, whereas the other side is 10 psi oxygen. Using the oxygen sensor on the nitrogen side, increase in oxygen concentration on the nitrogen side with time could be monitored. The time required for oxygen to permeate through the disk, or for oxygen concentration on the nitrogen side to reach a constant value, is recorded and used to determine the oxygen permeability.

Mixing BIMS with Cloisite clays and amines was performed using a Brabender™ mixer at 150°C and 60 RPM. Curatives were added subsequently in a mill. Cloisite clays were dried overnight prior to their usage in mixing. Compositions of these mixes are listed in Table 2. Tertiary amines were added in 0.5 and 1 mole equivalent of bromine, respectively. Rubber and tertiary amines were added first for 6 minutes followed by Cloisite clay for another 5 minutes. All BIMS blends were cured to prepare pads for permeability measurement using a Mocon permeability tester. Permeability values are listed in Tables 2 through 5 for selected compositions 1A-8A, 1B-8B, 1C-8C, and 1D-4D. The data show that the addition of the tertiary amines and polyfunctional curatives improves the air impermeability of the BIMS interpolymers. In Table 4, the addition of a pre-treated clay along with a tertiary amine is shown to further improve the air impermeability of the BIMS interpolymers samples 3C and 7C. In Table 5, the addition of the treated clay and amine is shown to improve the air impermeability of a BIMS interpolymers having a bromine level of 1.2 mol%.

The present invention includes nanocomposite blends of functionalized amines as described above with halogenated elastomers such as commercially available bromo- and chlorobutyl rubber and brominated and chlorinated star branched butyl (*e.g.*, Butyl 1065 & 2222 and Butyl 6666, ExxonMobil Chemical Company, Houston TX), and EXXPRO™ Elastomers (ExxonMobil Chemical Company, Houston TX), and optionally a thermoplastic. These blends are exemplified by the following examples. Permeability measurements were made of the cured compositions by compression molding at 200°C pads, followed by measurements on a MOCON permeability tester. Samples 1E through 14E are representative of the functionalized amines and blends of these amines with BIMS and clay materials.

The halogenated elastomer may be first combined with the functionalized amine to produce an amine functionalized elastomer. The elastomer and amine can be combined without a solvent in one embodiment. In another embodiment, a solvent such as cyclohexane, tetrahydrofuran (THF) hexane, and other hydrocarbon solvents are combined with the functionalized amine and elastomer. In a first example, 100 g of EXXPRO™ 96-4 (10 wt% PMS; 0.85 mol% Br) was dissolved in 1200 mL of cyclohexane. The polymer cement was heated to 70°C, and 2-(dimethylamino)ethyl methacrylate (5.2 g) was added. The reaction was kept at 70°C for 3 hours. The product was precipitated by adding 2000 mL of isopropyl alcohol to the polymer cement. The functionalized polymer was then dried in vacuum at a temperature of 60°C for 14 hours.

In a second example, 100 g of EXXPRO™ 96-4 (10 wt% PMS; 0.8 mol% Br) was dissolved in 1200 mL of cyclohexane. The polymer cement was heated to 70°C, and 2-(diethylamino)ethyl methacrylate (7.9 g) was added. The reaction was kept at 70°C for 3 hours. The product was precipitated by adding 2000 mL of isopropyl alcohol to the polymer cement. The functionalized polymer was then dried in vacuum at a temperature of 60°C for 14 hours.

In a third example, 52.5 grams of EXXPRO™ 89-1 (5 wt% PMS; 0.75 mol% Br) is dissolved in 800 ml of THF at room temperature (20°C). To the solution is added 0.98 grams of dimethylaminobenzoic acid. The resulting mixture is stirred for 4 hrs. and then transferred into acetone to afford a elastomer including at least one or more amine-functionalized monomer units. To this functionalized elastomer is added 4.5 grams of clay (CLOISITE 6A), the mixture then blended in a Brabender at 160°C for 10 minutes with a rotor speed of 60 rpm. The product was collected, and TEM images were consistent with formation of a nanocomposite.

In other embodiments, the elastomer and functionalized amine, with or without solvent, may be blended at from 10°C to 250°C, and from 20°C to 200°C in another embodiment. In yet another embodiment, the components may be blended at from 10°C to the melting point of the elastomer. The elastomer may be pre-blended by any suitable means with the functionalized amine prior to blending with the clay in one embodiment. In another embodiment, the elastomer, amine, and clay may be blended in one step.

Examples blends 1E-4E of blended functionalized amines, elastomers and clays, and measurements of air permeability (permeability and permeation rate) (40°C), are shown in Table 6 and prepared as above. These data show that the presence of the functionalized amines with the elastomer improve the air barrier quality of the nanocomposite. The clays are present in the composition from 1 phr to 50 phr in one embodiment, and from 6 phr to 30 phr in yet another embodiment, and from 5 phr to 25 phr in yet another embodiment. Expressed another way, the clay may be present in the composition from 0.5 wt% to 20 wt% in one embodiment, based on the weight of the composition, and from 0.5 wt% to 15 wt% in another embodiment. The clays may be pretreated with an amine such as described above in one embodiment, or not pretreated in another embodiment.

The functionalized amines may be present from 0.1 phr to 15 phr in one embodiment, and from 0.2 to 10 phr in yet another embodiment. Expressed another way, the functionalized amines may be present from 0.1 wt% to 15 wt% in one embodiment, and from 0.2 wt% to 10 wt% in another embodiment.

In a further example of the functionalized amine blends with halogenated elastomers, a bromobutyl polymer (BIIR 2222) was blended as indicated in Table 7. The BIIR is first blended in a Brabender at a rotor speed of 60 rpm for about one minute, followed by addition of the functionalized amine N,N'-diethanolamine (DEEAM). After the mixture was blended for 10 minutes, the exfoliated clay is added (6A). The blend was then further mixed for an additional 10 minutes. The samples were then dried under vacuum at 120°C for 24 hours, followed by measurement of the air permeation rate at 40°C. For comparison, BIIR 2222 alone that has been vacuum dried at 120°C for 24 hrs. was also measured. These results are shown in Table 7. The amine-functionalized halogenated elastomers in the samples 5E-7E shown an improved permeation rate relative to the halogenated elastomer alone.

The permeability rates of the nanocomposite compositions of the present invention are desirably less than 150 cc·mm/m²·day in one embodiment (at 40°C), and less than 140 cc·mm/m²·day in another embodiment, and less than 120 cc·mm/m²·day in yet another embodiment, and less than 150 cc·mm/m²·day in yet another embodiment, and desirably, less than 110 cc·mm/m²·day in yet another embodiment, and less than 100 cc·mm/m²·day in yet another embodiment.

In yet a further example of the functionalized amine blends with halogenated elastomers, another BIMS elastomer (EXXPRO™ 89-1) was blended with exfoliated clay and either dimethylamino-1-propanol (DMAMP) or N,N'-diethylethanolamine (DEEAM) as shown in Table 8. The elastomer was first

blended in a Brabender at a rotor speed of 60 rpm for about one minute, followed by addition of the functionalized amine. After the mixture is blended for 10 minutes, the exfoliated clay is added (6A). The blend is then further mixed for an additional 10 minutes. The samples were then dried under vacuum at 120°C for 24 hours, followed by measurement of the air permeation rate at 40°C as labeled samples 8E through 14E. For comparison, EXXPRO™ 89-1 alone that has been vacuum dried at 120°C for 24 hrs. was also measured. These results are shown in Table 8.

Embodiments of the final nanocomposite of the present invention are useful as air barriers, such as used in producing innerliners for motor vehicles. In particular, the nanocomposites are useful in innerliners and innertubes for articles such as truck tires, bus tires, passenger automobile, motorcycle tires, off the road tires, and the like. The improved heat aging resistance of the present innerliner composition makes it particularly suited for use in truck tires to increase the retreading capability of the tire.

While the present invention has been described and illustrated by reference to particular embodiments, those of ordinary skill in the art will appreciate that the invention lends itself to many different variations not illustrated herein. For these reasons, then, reference should be made solely to the appended claims for purposes of determining the true scope of the present invention.

All priority documents are herein fully incorporated by reference for all jurisdictions in which such incorporation is permitted. Further, all documents cited herein, including testing procedures, are herein fully incorporated by reference for all jurisdictions in which such incorporation is permitted.

Table 1. Material Description

Designation	Description	Material
BIMS 89-1	BIMS rubber, 35 ML ¹ , 0.75 mol% Br, 5 wt% PMS	EXXPRO 89-1, ExxonMobil Chemical
BIMS 89-4	BIMS rubber, 45 ML*, 0.75 mol % Br, 5 wt % PMS	EXXPRO 89-4, ExxonMobil Chemical
BIMS 96-4	BIMS rubber, 45 ML ¹ , 0.85 mol% Br, 10 wt% PMS	EXXPRO 96-4, ExxonMobil Chemical
BIMS 3035	BIMS rubber, 45 ML*, 0.48 mol % Br, 5 wt % PMS	EXXPRO Elastomers 3035, ExxonMobil Chemical
BIMS 3745	BIMS rubber, 45 ML*, 1.2 mol % Br, 7.5 wt % PMS	EXXPRO Elastomers 3745, ExxonMobil Chemical
BIIR 2222	Bromobutyl rubber, 2 wt% Br	ExxonMobil Chemical
DM16D	Tertiary amine, hexadecyl-dimethylamine	Armeen DM16D, Akzo Nobel Chemical
DMAMP	dimethylamino-1-propanol	Aldrich Chemical
2-(diethylamino)ethyl methacrylate	2-(diethylamino)ethyl methacrylate	Sanester Corporation or Aldrich Chemical
2-(dimethylamino)ethyl methacrylate	2-(dimethylamino)ethyl methacrylate	Sanester Corporation or Aldrich Chemical
DEEAM	N,N'-diethylethanolamine	Aldrich Chemical
M2HT	Tertiary amine, dihydrogenated tallowalkyl-methylamine**	Armeen M2HT, Akzo Nobel Chemical
6A	Montmorillonite clay treated with di-methyl di-hydrogenated tallow alkyl ammonia chloride	Cloisite 6A, Southern Clay
20A	Montmorillonite clay treated with di-methyl-dihydrogenated tallow alkyl ammonium chloride	Cloisite 20A, Southern Clay
Na	Montmorillonite clay with Na counter ions	Cloisite Na, Southern Clay
HTS	Hexamethylene bithiosulfate disodium salt	Flexsys Duralink HTS
Acetylene Black	Carbon Black	e.g., Harwick Standard; R.T. Vanderbilt; Degussa-Huls.
THF-N	Amine terminated polytetrahydrofuran	Aldrich Chemical

*: ML is Mooney viscosity (1+8) measured at 125°C and ~1 s⁻¹.

** : hydrogenated tallow contains saturated 3.5% C14, 0.5% C15, 31% C16, 1% C17, 61% C18 and unsaturated 3% C18 (2/3 of the alkyl group is C18)

Table 2. BIMS Clays Blends with DM16D/M2HT and Na (Untreated Clay)

Component (phr)	1A	2A	3A	4A	5A	6A	7A	8A
BIMS 8-94	200	200	200	200	180	180	180	180
Na (Clay)	10	10	10	10	18	18	18	18
DM16D (t-amine)	3.6	7.2	0	0	3.2	6.4	0	0
M2HT (t-amine)	0	0	7	14	0	0	6.3	12.6
ZnO	2	2	2	2	1.8	1.8	1.8	1.8
Zn Stearate	2	2	2	2	1.8	1.8	1.8	1.8
Stearic Acid	4	4	4	4	3.6	3.6	3.6	3.6
Permeability (cc·mil/(m ² ·day·mmHg))	-	-	25.1	26.9	-	-	22.3	25.4

Table 3. BIMS Clay Blends with HTS/THF-N

Component (phr)	1B	2B	3B	4B	5B	6B	7B	8B
BIMS 3035	100	100	100	100	100	100	100	100
THF-N (amine)	0	0	0	0	0	0	1	1
6A (clay)	0	0	9	0	9	0	0	0
Na (clay)	0	0	0	9	0	9	9	9
Carbon Black	30	30	30	30	30	30	30	30
Zinc Oxide	2	0	2	2	0	0	2	0
Zinc Octoate	0	2	0	0	2	2	0	2
HTS (thiosulfate)	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
Permeability (cc·mil/(m ² ·day·mmHg))	19.1	19.9	18.7	16.9	19.3	17.0	17.1	16.8

Table 4. BIMS Clays Blends with DM16D/M2HT and 6A (Treated Clay)

Component (phr)	1C	2C	3C	4C	5C	6C	7C	8C
BIMS 8-94	200	200	200	200	180	180	180	180
6A (clay)	10	10	10	10	18	18	18	18
DM16D (amine)	3.6	7.2	0	0	3.2	6.4	0	0
M2HT (amine)	0	0	7	14	0	0	6.3	12.6
ZnO	2	2	2	2	1.8	1.8	1.8	1.8
Zn Stearate	2	2	2	2	1.8	1.8	1.8	1.8
Stearic Acid	4	4	4	4	3.6	3.6	3.6	3.6
Permeability (cc·mil/(m ² ·day·mmHg))	23.7	-	17.3	-	-	-	15.7	-

Table 5. BIMS/CB Compounds Containing Clays and DM16D/M2HT

Component (phr)	1D	2D	3D	4D
BIMS 3745	100	100	100	100
N660 (carbon black)	60	60	60	60
6A (clay)	0	3	3	3
DM16D (amine)	0	0	1.48	0
M2HT (amine)	0	0	0	0.96
ZnO	1	1	1	1
MBTS	1.25	1.25	1.25	1.25
S	0.5	0.5	0.5	0.5
Stearic Acid	1	1	1	1
Permeability (cc·mil/(m ² ·day·mmHg))	15.85	15.38	13.68	12.92

**Table 6. Permeability and Permeation rate values of
BIMS 96-4/functionalized amine blends with exfoliated clay.**

component (phr)	1E	2E	3E	4E
EXXPRO 96-4	100	100	100	100
6A clay	10	10	10	10
dimethylaminoethyl methacrylate	0.5	1.5	3	5.3
Permeability coefficient, cc·mil/(m ² ·day·mmHg)	3.9	5	5.6	6.2
Permeation Rate cc·mm/m ² ·day	76.7	98.2	109.9	122.7

Table 7. Permeation rates of BIIR 2222 /functionalized amine blends with exfoliated clay.

Sample	Polymer (grams)	Clay type (grams)	Modifier (mg)	Mixing Temp (°C)	Permeation rate (mm·cc/[m ² ·day]) At 40 °C
comparative BIIR	-	-	-	-	156.2
5E	43	Cloisite 6Å (3.7)	DEEAM (450 mg)	140	132.2
6E	43	Cloisite 6Å (3.7)	DEEAM (300 mg)	140	128.5
7E	43	Cloisite 6Å (3.7)	DEEAM (150 mg)	140	141.9

Table 8. Permeation rates of BIMS 89-1 /functionalized amine blends with exfoliated clay.

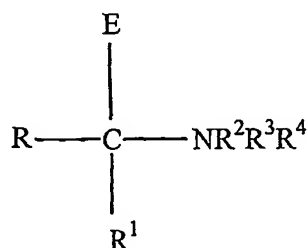
Sample	Polymer (gram)	Clay type (gram)	Modifier (mg)	Mixing Temp (°C)	O ₂ Permeation rate (mm.cc/[m ² .day]) at 40 °C
comparative BIMS 89-1	-	-	-	-	143.2
8E	41	Cloisite 6A (3.5)	DMAMP (600 mg)	120	N/A ¹
9E	41	Cloisite 6A (3.5)	DMAMP (350 mg)	120	N/A ¹
10E	41	Cloisite 6A (3.5)	DMAMP (150 mg)	120	N/A ¹
11E	41	Cloisite 6A (3.5)	DEEAM (685 mg)	120	127.3
12E	41	Cloisite 6A (3.5)	DEEAM (398 mg)	120	111.8
13E	41	Cloisite 6A (3.5)	DEEAM (170 mg)	120	117.5
14E	41	Cloisite 20A (3.5)	DEEAM (685 mg)	120	145.4

1. could not be measured due to high level of crosslinking.

CLAIMS

We claim:

1. A nanocomposite comprising a clay and a halogenated elastomer comprising C₄ to C₇ isoolefin derived units; wherein the halogenated elastomer also comprises an amine-functionalized monomer unit described by the following group pendant to the elastomer E:

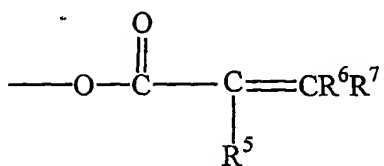


wherein R and R¹ are the same or different and are one of a hydrogen, C₁ to C₇ alkyls, and primary or secondary alkyl halides; and wherein R², R³ and R⁴ are the same or different and are selected from hydrogen, C₁ to C₂₀ alkyls, alkenes or aryls, substituted C₁ to C₂₀ alkyls, alkenes or aryls, C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, ester and ammonium ions.

2. The nanocomposite of Claim 1, wherein the halogenated elastomer comprises C₄ to C₇ isoolefin derived units, para-methylstyrene derived units and a para-(halomethylstyrene) derived units.
3. The nanocomposite of Claim 1, wherein the halogenated elastomer comprises C₄ to C₇ isoolefin derived units, multiolefin derived units, and halogenated multiolefin derived units.
4. The nanocomposite of Claim 1, wherein at least one of R², R³ and R⁴ are selected from C₁ to C₂₀ alkenes, C₁ to C₂₀ aliphatic alcohols, C₁ to C₂₀

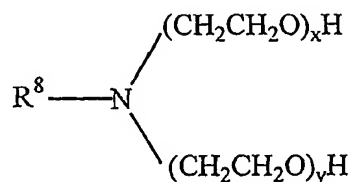
aliphatic ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.

5. The nanocomposite of Claim 1, wherein at least one of R², R³ and R⁴ is selected from C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, esters, ammonium ions, or acrylate groups; wherein the acrylate is described by the following formula:



wherein R⁵, R⁶ and R⁷ are the same or different and are one of a hydrogen and a C₁ to C₇ alkyl or alkenyl.

6. The nanocomposite of Claim 1, wherein the amine functional group is selected from ethoxylated amines having the following structure:



wherein R⁸ is a C₁ to C₂₀ alkyl; and wherein x + y is 2, 5, 10, 15, or 50.

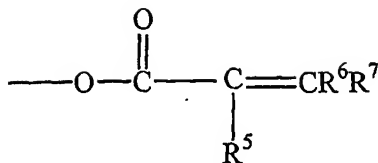
7. The nanocomposite of Claim 1, wherein the amine functional group is selected from diallylamine, dimethylaminoethylacrylate, dimethylaminomethylacrylate, N-methylamino-bis-2-propanol, N-ethylamino-bis-2-propanol, dimethylaminoethylmethacrylate, diethylaminopropanol, diethylethanolamine, dimethylamino-1-propanol, tripropanolamine, triethanolamine, aminolauric acid, and betaine, and combinations thereof.

8. The nanocomposite of Claim 1, wherein the amine-functionalized derived unit is present on the halogenated elastomer from 0.01 wt% to 10 wt% of the nanocomposite.
- 5
9. The nanocomposite of Claim 1, wherein the clay is an exfoliated clay.
10. The nanocomposite of Claim 8, wherein the exfoliating agent is selected from ammonium ion, alkylamines, alkylammonium ion (primary, secondary, tertiary and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides and blends thereof.
- 10
11. The nanocomposite of Claim 1, wherein the clay is present from 0.1 wt% to 50 wt% of the nanocomposite.
- 15
12. The nanocomposite of Claim 1, wherein the clay is present from 0.5 wt% to 30 wt% of the nanocomposite.
- 20
13. The nanocomposite of Claim 1, wherein the clay is present in the nanocomposite from 1 wt% to 10 wt% of the nanocomposite.
- 25
14. The nanocomposite of Claim 1, further comprising a polyfunctional curative selected from structures described by the formula $Z-R^{17}-Z'$, wherein R^{17} is one of a C_1 to C_{15} alkyl, C_2 to C_{15} alkenyl, and C_6 to C_{12} cyclic aromatic moiety, substituted or unsubstituted; and Z and Z' are the same or different and are one of a thiosulfate group, mercapto group, aldehyde group, carboxylic acid group, peroxide group, alkenyl group, or other similar group that is capable of crosslinking, either intermolecularly

or intramolecularly, one or more strands of a polymer having reactive groups such as unsaturation.

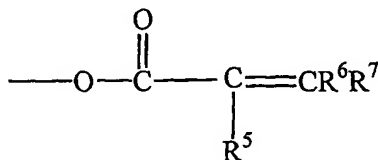
- 5 15. The nanocomposite of Claim 1, also comprising a filler selected from carbon black, modified carbon black, silica, precipitated silica, and blends thereof.
16. The nanocomposite of Claim 1, also comprising curing agents.
- 10 17. The nanocomposite of Claim 15, wherein the curing agents comprise zinc, zinc stearate, fatty acids, sulfur, or mixtures thereof.
18. The nanocomposite of Claim 1, also comprising a secondary rubber selected from natural rubber, polybutadiene rubber, nitrile rubber, silicon
15 rubber, polyisoprene rubber, poly(styrene-*co*-butadiene) rubber, poly(isoprene-*co*-butadiene) rubber, styrene-isoprene-butadiene rubber, ethylene-propylene rubber, brominated butyl rubber, chlorinated butyl rubber, halogenated isoprene, halogenated isobutylene copolymers, polychloroprene, star-branched polyisobutylene rubber, star-branched
20 brominated butyl rubber, poly(isobutylene-*co*-isoprene) rubber; halogenated poly(isobutylene-*co*-*p*-methylstyrene) and mixtures thereof.
19. The nanocomposite of Claim 61, wherein the halogenated multiolefin units are primarily allylic halogenated units present to at least 20 mol% of the
25 halogenated multiolefin units.
20. A tire innerliner comprising the nanocomposite of Claim 1.
21. An innertube comprising the nanocomposite of Claim 1.
- 30

22. A nanocomposite comprising a clay, a halogenated elastomer comprising C₄ to C₇ isoolefin derived units; and a functionalized amine; wherein the functionalized amine is described by the formula NR²R³R⁴, wherein R², R³ and R⁴ are the same or different and are selected from hydrogen, C₁ to C₂₀ alkyls, alkenes or aryls, substituted C₁ to C₂₀ alkyls, alkenes or aryls, C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.
23. The nanocomposite of Claim 22, wherein the halogenated elastomer comprises C₄ to C₇ isoolefin derived units, para-methylstyrene derived units and a para-(halomethylstyrene) derived units.
24. The nanocomposite of Claim 22, wherein the halogenated elastomer comprises C₄ to C₇ isoolefin derived units, multiolefin derived units, and halogenated multiolefin derived units.
25. The nanocomposite of Claim 22, wherein at least one of R², R³ and R⁴ are selected from C₁ to C₂₀ alkenes, C₁ to C₂₀ aliphatic alcohols, C₁ to C₂₀ aliphatic ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.
26. The nanocomposite of Claim 22, wherein at least one of R², R³ and R⁴ is selected from C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, esters, ammonium ions, or acrylate groups; wherein the acrylate is described by the following formula:



wherein R^5 , R^6 and R^7 are the same or different and are one of a hydrogen and a C_1 to C_7 alkyl or alkenyl.

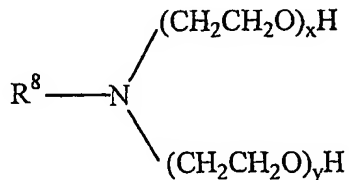
- 5 27. The nanocomposite of Claim 22, wherein at least one of R^2 , R^3 and R^4 is selected from C_1 to C_{20} aliphatic alcohols or ethers, C_1 to C_{20} carboxylic acids, nitriles, esters, ammonium ions, or acrylate groups; wherein the acrylate is described by the following formula:



10 wherein R^5 , R^6 and R^7 are the same or different and are one of a hydrogen and a C_1 to C_7 alkyl or alkenyl.

28. The nanocomposite of Claim 22, wherein the amine functional group is selected from ethoxylated amines having the following structure:

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wherein R^8 is a C_1 to C_{20} alkyl; and wherein $x + y$ is 2, 5, 10, 15, or 50.

29. The nanocomposite of Claim 22, wherein the amine functional group is selected from dimethylaminoethylacrylate, dimethylaminomethylacrylate,
- 20

diallylamine, N-methylamino-bis-2-propanol, N-ethylamino-bis-2-propanol, dimethylaminoethylmethacrylate, diethylaminopropanol, diethylethanolamine, dimethylamino-1-propanol, tripropanolamine, triethanolamine, aminolauric acid, and betaine, and combinations thereof.

5

30. The nanocomposite of Claim 22, wherein the amine-functionalized derived unit is present on the halogenated elastomer from 0.01 wt% to 10 wt% of the nanocomposite.

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31. The nanocomposite of Claim 22, wherein the clay is an exfoliated clay.

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32. The nanocomposite of Claim 31, wherein the exfoliating agent is selected from ammonium ion, alkylamines, alkylammonium ion (primary, secondary, tertiary and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides and blends thereof.

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33. The nanocomposite of Claim 22, wherein the clay is present from 0.1 wt% to 50 wt% of the nanocomposite.

34. The nanocomposite of Claim 22, wherein the clay is present from 0.5 wt% to 30 wt% of the nanocomposite.

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35. The nanocomposite of Claim 22, wherein the clay is present in the nanocomposite from 1 wt% to 10 wt% of the nanocomposite.

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36. The nanocomposite of Claim 22, further comprising a polyfunctional curative selected from structures described by the formula $Z-R^{17}-Z'$, wherein R^{17} is one of a C_1 to C_{15} alkyl, C_2 to C_{15} alkenyl, and C_6 to C_{12} cyclic aromatic moiety, substituted or unsubstituted; and Z and Z' are the

same or different and are one of a thiosulfate group, mercapto group, aldehyde group, carboxylic acid group, peroxide group, alkenyl group, or other similar group that is capable of crosslinking, either intermolecularly or intramolecularly, one or more strands of a polymer having reactive groups such as unsaturation.

37. The nanocomposite of Claim 22, also comprising a filler selected from carbon black, modified carbon black, silica, precipitated silica, and blends thereof.

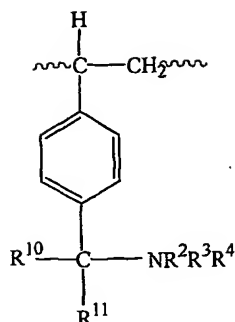
38. The nanocomposite of Claim 22, also comprising curing agents.

39. The nanocomposite of Claim 38, wherein the curing agents comprise zinc, zinc stearate, fatty acids, sulfur, or mixtures thereof.

40. The nanocomposite of Claim 22, also comprising a secondary rubber selected from natural rubber, polybutadiene rubber, nitrile rubber, silicon rubber, polyisoprene rubber, poly(styrene-*co*-butadiene) rubber, poly(isoprene-*co*-butadiene) rubber, styrene-isoprene-butadiene rubber, ethylene-propylene rubber, brominated butyl rubber, chlorinated butyl rubber, halogenated isoprene, halogenated isobutylene copolymers, polychloroprene, star-branched polyisobutylene rubber, star-branched brominated butyl rubber, poly(isobutylene-*co*-isoprene) rubber; halogenated poly(isobutylene-*co*-*p*-methylstyrene) and mixtures thereof.

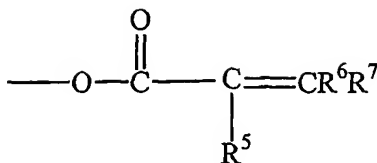
41. An innertube comprising the nanocomposite of Claim 22.

42. A nanocomposite comprising a clay, and an interpolymer; wherein the interpolymer comprises amine-functionalized monomer unit described by the following:



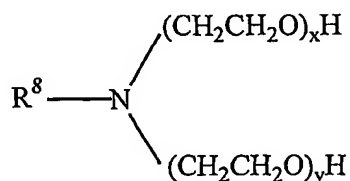
wherein R^{10} and R^{11} are the same or different and are one of a hydrogen, C_1 to C_7 alkyls, and primary or secondary alkyl halides; and wherein R^2 , R^3 and R^4 are the same or different and are selected from hydrogen, C_1 to C_{20} alkyls, alkenes or aryls, substituted C_1 to C_{20} alkyls, alkenes or aryls, C_1 to C_{20} aliphatic alcohols or ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.

43. The nanocomposite of Claim 42, wherein the interpolymer also comprises C_4 to C_7 isoolefin derived units, para-methylstyrene derived units and para-(halomethylstyrene) derived units.
44. The nanocomposite of Claim 42, wherein at least one of R^2 , R^3 and R^4 are selected from C_1 to C_{20} alkenes, C_1 to C_{20} aliphatic alcohols, C_1 to C_{20} aliphatic ethers, C_1 to C_{20} carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.
45. The nanocomposite of Claim 42, wherein at least one of R^2 , R^3 and R^4 is a C_1 to C_{20} aliphatic alcohol or ether, C_1 to C_{20} carboxylic acid, nitrile, ester, ammonium ion, or acrylate group; wherein the acrylate is described by the following formula:



wherein R^5 , R^6 and R^7 are the same or different and are one of a hydrogen and a C_1 to C_7 alkyl or alkenyl.

- 5 46. The nanocomposite of Claim 42, wherein the amine functional group is selected from ethoxylated amines having the following structure:



wherein R^8 is a C_1 to C_{20} alkyl; and wherein $x + y$ is 2, 5, 10, 15, or 50.

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47. The nanocomposite of Claim 42, wherein the amine functional group is selected from dimethylaminoethylacrylate, dimethylaminomethylacrylate, N-methylamino-bis-2-propanol, diallylamine, N-ethylamino-bis-2-propanol, dimethylaminoethylmethacrylate, diethylaminopropanol, diethylethanolamine, dimethylamino-1-propanol, tripropanolamine, triethanolamine, aminolauric acid, and betaine, and combinations thereof.

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48. The nanocomposite of Claim 42, wherein the amine-functionalized derived unit is present on the halogenated elastomer from 0.01 wt% to 10 wt% of the nanocomposite.

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49. The nanocomposite of Claim 42, wherein the clay is an exfoliated clay.

50. The nanocomposite of Claim 49, wherein the exfoliating agent is selected from ammonium ion, alkylamines, alkylammonium ion (primary, secondary, tertiary and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides and blends thereof.
51. The nanocomposite of Claim 42, wherein the clay is present from 0.1 wt% to 50 wt% of the composition.
52. The nanocomposite of Claim 42, wherein the clay is present from 0.5 wt% to 30 wt% of the nanocomposite.
53. The nanocomposite of Claim 42, wherein the clay is present from 1 wt% to 10 wt% of the nanocomposite.
54. The nanocomposite of Claim 42, further comprising a polyfunctional curative selected from structures described by the formula $Z-R^{17}-Z'$, wherein R^{17} is one of a C_1 to C_{15} alkyl, C_2 to C_{15} alkenyl, and C_6 to C_{12} cyclic aromatic moiety, substituted or unsubstituted; and Z and Z' are the same or different and are one of a thiosulfate group, mercapto group, aldehyde group, carboxylic acid group, peroxide group, alkenyl group, or other similar group that is capable of crosslinking, either intermolecularly or intramolecularly, one or more strands of a polymer having reactive groups such as unsaturation.
55. The nanocomposite of Claim 42, also comprising a filler selected from carbon black, modified carbon black, silica, precipitated silica, and blends thereof.
56. The nanocomposite of Claim 42, also comprising curing agents.

57. The nanocomposite of Claim 56, wherein the curing agents comprise zinc, zinc stearate, fatty acids, sulfur, or mixtures thereof.
- 5 58. The nanocomposite of Claim 42, also comprising a secondary rubber selected from natural rubber, polybutadiene rubber, nitrile rubber, silicon rubber, polyisoprene rubber, poly(styrene-*co*-butadiene) rubber, poly(isoprene-*co*-butadiene) rubber, styrene-isoprene-butadiene rubber, ethylene-propylene rubber, brominated butyl rubber, chlorinated butyl
10 rubber, halogenated isoprene, halogenated isobutylene copolymers, polychloroprene, star-branched polyisobutylene rubber, star-branched brominated butyl rubber, poly(isobutylene-*co*-isoprene) rubber; halogenated poly(isobutylene-*co-p*-methylstyrene) and mixtures thereof.
- 15 59. An innerliner comprising the nanocomposite of Claim 42.
60. An innertube comprising the nanocomposite of Claim 42.
- 20 61. A method of forming a nanocomposite comprising combining clay; a halogenated elastomer comprising C₄ to C₇ isoolefin derived units and, a functionalized amine; wherein the functionalized amine is described by the formula NR²R³R⁴, wherein R², R³ and R⁴ are the same or different and are selected from hydrogen, C₁ to C₂₀ alkyls, alkenes or aryls, substituted C₁ to C₂₀ alkyls, alkenes or aryls, C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀
25 carboxylic acids, nitriles, acrylates, esters and ammonium ions.
62. The method of Claim 61, wherein the elastomer and functionalized amine are combined in a first step, followed by blending with at least one clay.

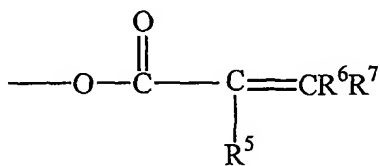
63. The method of Claim 61, wherein the elastomer, functionalized amine, and clay are combined in a single blending step.

64. The method of Claim 61, wherein the halogenated elastomer comprises C₄ to C₇ isoolefin derived units, para-methylstyrene derived units and a para-(halomethylstyrene) derived units.

65. The method of Claim 61, wherein the halogenated elastomer comprises C₄ to C₇ isoolefin derived units, multiolefin derived units, and halogenated multiolefin derived units.

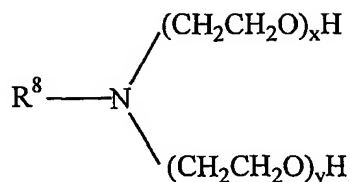
66. The method of Claim 61, wherein at least one of R², R³ and R⁴ are selected from C₁ to C₂₀ alkenes, C₁ to C₂₀ aliphatic alcohols, C₁ to C₂₀ aliphatic ethers, C₁ to C₂₀ carboxylic acids, nitriles, ethoxylated amines, acrylates, esters and ammonium ions.

67. The method of Claim 61, wherein at least one of R², R³ and R⁴ is selected from C₁ to C₂₀ aliphatic alcohols or ethers, C₁ to C₂₀ carboxylic acids, nitriles, esters, ammonium ions, or acrylate groups; wherein the acrylate is described by the following formula:



wherein R⁵, R⁶ and R⁷ are the same or different and are one of a hydrogen and a C₁ to C₇ alkyl or alkenyl.

68. The method of Claim 61, wherein the amine functional group is selected from ethoxylated amines having the following structure:



wherein R^8 is a C_1 to C_{20} alkyl; and wherein $x + y$ is 2, 5, 10, 15, or 50.

- 5 69. The method of Claim 61, wherein the amine functional group is selected from dimethylaminoethylacrylate, dimethylaminomethylacrylate, N-methylamino-bis-2-propanol, allylamine, N-ethylamino-bis-2-propanol, dimethylaminoethylmethacrylate, diethylaminopropanol, diethylethanolamine, dimethylamino-1-propanol, tripropanolamine, triethanolamine, aminolauric acid, and betaine, and combinations thereof.
- 10 70. The method of Claim 61, wherein the amine-functionalized derived unit is present on the halogenated elastomer from 0.01 wt% to 10 wt% of the nanocomposite.
- 15 71. The method of Claim 61, wherein the clay is an exfoliated clay.
- 20 72. The method of Claim 61, wherein the exfoliating agent is selected from ammonium ion, alkylamines, alkylammonium ion (primary, secondary, tertiary and quaternary), phosphonium or sulfonium derivatives of aliphatic, aromatic or arylaliphatic amines, phosphines and sulfides and blends thereof.
- 25 73. The method of Claim 61, wherein the clay is present from 0.1 wt% to 50 wt% of the composition.
74. The method of Claim 61, wherein the clay is present in the nanocomposite from 0.5 wt% to 30 wt% of the nanocomposite.

75. The method of Claim 61, wherein the clay is present in the nanocomposite from 1 wt% to 10 wt% of the nanocomposite.
- 5 76. The method of Claim 61, further comprising a polyfunctional curative selected from structures described by the formula $Z-R^{17}-Z'$, wherein R^{17} is one of a C_1 to C_{15} alkyl, C_2 to C_{15} alkenyl, and C_6 to C_{12} cyclic aromatic moiety, substituted or unsubstituted; and Z and Z' are the same or different and are one of a thiosulfate group, mercapto group, aldehyde group, 10 carboxylic acid group, peroxide group, alkenyl group, or other similar group that is capable of crosslinking, either intermolecularly or intramolecularly, one or more strands of a polymer having reactive groups such as unsaturation.
- 15 77. The method of Claim 61, also comprising a filler selected from carbon black, modified carbon black, silica, precipitated silica, and blends thereof.
78. The method of Claim 61, also comprising curing agents.
- 20 79. The method of Claim 78, wherein the curing agents comprise zinc, zinc stearate, fatty acids, sulfur, or mixtures thereof.
80. The method of Claim 61, also comprising a secondary rubber selected from natural rubber, polybutadiene rubber, nitrile rubber, silicon rubber, 25 polyisoprene rubber, poly(styrene-co-butadiene) rubber, poly(isoprene-co-butadiene) rubber, styrene-isoprene-butadiene rubber, ethylene-propylene rubber, brominated butyl rubber, chlorinated butyl rubber, halogenated isoprene, halogenated isobutylene copolymers, polychloroprene, star-branched polyisobutylene rubber, star-branched brominated butyl rubber,

poly(isobutylene-*co*-isoprene) rubber; halogenated poly(isobutylene-*co*-*p*-methylstyrene) and mixtures thereof.

- 5 81. The method of Claim 61, wherein the halogenated multiolefin units are primarily allylic halogenated units present to at least 20 mol% of the halogenated multiolefin units.
82. An innerliner made by the method of Claim 61.
- 10 83. An innertube made by the method of Claim 61.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US02/16796

A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) : C08K 3/00

US CL : 524/445

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 524/445

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
EAST

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5,807,629 A (ELSPASS et al) 15 September 1998, entire document.	1-5, 8-27, 30-45, 48-67, 70-83
X	US 5,576,372 A (KRESGE et al) 19 November 1996, entire document.	1-83
X	US 6,060,549 A (LI et al.) 09 May 2000, entire document.	1-83
Y	US 5,665,183 A (KRESGE et al) 09 September 1997, entire document.	1-83
Y	US 5,883,173 A (ELSPASS et al.) 16 March 1999, entire document.	1-83
Y	US 6,232,389 B1 (FEENEY et al.) 15 May 2001, entire document.	1-83
Y	US 6,087,016 A (FEENEY et al.) 11 July 2000, entire document	1-83
Y	US 5,952,093 A (NICHOLS et al.) 14 September 1999, entire document.	1-83

☐ Further documents are listed in the continuation of Box C.

☐ See patent family annex.

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"&" document member of the same patent family

Date of the actual completion of the international search

21 August 2002 (21.08.2002)

Date of mailing of the international search report

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